

Work Order ID 128136

128136

Page 1

Thursday, January 08, 2015 8:41:09 AM

Item ID: D350-636-016

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/8/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS Date: 1501-08

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4168-042	B
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100

Document Control

0.00

DAG
27
8-00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

record fwd angle:

89.5°

DGC

1x

DAS
46
Q.20

JAN 15 2015

Photocopy blue file and type labels per PPP D350-636-016 CHG 005

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Item ID: D350-636-016 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float
 Start Date: 1/8/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/8/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	4- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. *6- ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section R-R and open to 0.500" 5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168 Detail J 6- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole 2- Open up holes of Detail J to 0.297" (total of 2 holes per side) +.201" (total of one hole per side) as per dwg D4168. 8- Weld D2744 Cap as per Dwg D4168 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: <u>ML30812</u> 9- Grind welds flush as per Dwg D4168								

DBL 15-1-8

7 BE15-01-08

DBC 15-1-8

7 BL15-01-08

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Item ID: D350-636-016**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Skidtube RH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible**Stop *NS2*****Start Date:** 1/8/2015 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/8/2015 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC10- Inspect visual per QSI004- ground welds	0.00							DAS 9 9-89
120									
QC	Memo	0.00							
Quality Control									

130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							DAS 9 9-89
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

15-1-8

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Item ID: D350-636-016**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Skidtube RH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible**Stop *NS2*****Start Date:** 1/8/2015 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/8/2015 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2*****Sequence ID/**
Work Center ID
150**Operation**
Description
QC7-Inspect Chemical Conversion Coat**Set Up/**
Run Hours
0.00**Tool ID** **Tool #** **Plan**
Code**Accept**
Qty**Reject**
Qty**Reject**
Number**Insp.**
Stamp***150***
QC

Memo

0.00

Quality Control

1 0 15-1-8 DGC

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Item ID: D350-636-016

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop ***NS2***

Start Date: 1/8/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/8/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

160

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes using hole saw of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168.

2-Open up holes using hole saw of Detail K to 0.750" (total of 4 holes per side) as per dwg D4168.

3- Open float hole to 0.500" using uni-bit (4 per side) and Run on wearplate holes to .375" 4 per side

4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015, let cure for 12hrs.

A/R Sikaflex-291 batch: 151120
exp. date: 15-10-21

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004 (welding instructions on sheet 8)

A/R Aluminum Rod batch: m130812

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D4168

DGL 15-1-8

DGL 15-1-8

BR 15-01-09

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop *NS2*

Start Date: 1/8/2015 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 1/8/2015 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168

12- C'bore section CH-CH. ADJUST TOOLING AS REQUIRED.
VERF BY:

13- Deburr holes, ensure tube is free of all scratches before sending to paint.

***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING
HOLE IN TUBE *****
***** REF TO W/O BATCH: *****

170

QC10- Inspect visual per QSI004- ground welds	0.00
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170

OC

Quality Control

Memo	0.00
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DAS
9
9-89

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Item ID: D350-636-016 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float
 Start Date: 1/8/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/8/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
180						①	15-01-10		DAS 9 9-89
QC	Memo	0.00							
Quality Control	***VERIFY C'BOARD IS GOOD***								
190	Pressure Wash per QSI005 4.3	0.00							DAS 41 9-89
190						1			15-1-10
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00							DAS 41 9-89
200						1			15-1-10
SprayPaint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>128975</u>								
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>131122</u>								

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Item ID: D350-636-016 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Stop *NS2*

Start Date: 1/8/2015 Start Qty: 1.00 *1*

Required Date: 1/8/2015 Req'd Qty: 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								
230		0.00							
230	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D4168								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168								
	SIKA FLEX 241								
	BATCH: <u>M121120</u>								
	EXP DATE: <u>13/08</u>								
	12TU 598 BHK M125792 ex 10 15/06/11								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>M129305</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>M122960</u>								

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Setup Start *NS1*

Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop *NS2*

Start Date: 1/8/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/8/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Status
240	QC5- Inspect part completeness to step on W/O	0.00							38

240

QC Memo

Quality Control

15-01-14

250	Pick Kit	0.00
-----	----------	------

250

Packaging	Memo	0.00
-----------	------	------

Packaging	If making a D350-636-216 pick kit will only requires:
	1 X AN3C37A
	1 X AN3C34A
	1 X AN3C42A
	2 X D3493-1

260	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

260

QC	Memo	0.00
Quality Control	*****ensure antiseize is on AN8C21A bolts*****	

DAS
46
Q-RQ

JAN 15 2015

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Item ID: D350-636-016 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible
 Start Date: 1/8/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/8/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00				(1x)	46 9.89	JAN 15 2015	
270	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-016								
Packaging	Location: _____ PPP rev: _____								
280	QC21- Final Inspection - Work Order Release	0.00							
280	Memo	0.00							
QC									
Quality Control									

MLJ 15-01-16

Picklist Print

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Work Order ID: 128136

128136

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B
11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as
per NCR 11-906 DD verf:EC IPP REV:D 13.08.28 PER ECN13-
594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3490-1		Manufactured	No			160	Each	117.0000	4	4			
D3490-1									**			BE15-01-09	
Cross Bolt Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001		117							
				125902		117							
D3490-3		Manufactured	No			160	Each	107.0000	4	4			
D3490-3									**			BE15-01-09	
Cross Bolt Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001		107							
				125903		107							
AN3C34A		Purchased	No			230	Each	13.0000	1	1			
AN3C34A									**			kl 15/01/13	
BOLT													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST347		13							
				m127044		13							

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Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

AN3C36A Purchased No 230 Each 145.0000 Start Qty: 1.00 4 4

AN3C36A

Bolt

**

15/01/13

Location	Loc Qty	Loc Code
FG	24	
101261	4	
116590	10	
122204	10	
FP001	27	
m129907	27	
ST338a	50	
m130874	50	
ST348	44	
m129907	44	

AN3C37A Purchased No 230 Each 170.0000

AN3C37A

BOLT

DAS
46
Q.RQ

**

DAS 27 06 9-89

Location	Loc Qty	Loc Code
ST338a	170	
M128773	80	
M129650	90	

AN3C42A Purchased No 230 Each 40.0000

AN3C42A

Bolt

DAS
46
Q.RQ

**

DAS 27 06 9-89

Location	Loc Qty	Loc Code
FG	5	
121103	5	
ST347	35	
m130460	5	
m130485	30	

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Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

D3488-042	Manufactured	No	230	Each	2.0000	Start Qty: 1.00 1	Required Qty: 1.00 1
D3488-042						**	ll 15/01/13
Blade Fitting RH							

Location	Loc Qty	Loc Code
FP001	2	B125899
125901	2	

✓1

D3492-1	Manufactured	No	230	Each	173.0000	8	8
D3492-1						**	ll 15/01/13
Plug							

Location	Loc Qty	Loc Code
FP001	173	
125904	173	

x8

D3492-3	Manufactured	No	230	Each	194.0000	8	8
D3492-3						**	ll 15/01/13
Plug							

Location	Loc Qty	Loc Code
FP001	194	
125905	194	

x8

D3873-1	Manufactured	No	230	Each	91.0000	7	7
D3873-1						**	ll 15/01/13
Bushing							

Location	Loc Qty	Loc Code
FP001	42	
124192	42	
ST063	49	
126709	49	

x7

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Parent Item: D350-636-016

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Parent Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

D4154-041 Manufactured No

230 Each

7.0000

Start Qty: 1.00

Required Qty: 1.00

1 1

D4154-041

Wearplate Assembly

**

15/01/15

Location

Loc Qty

Loc Code

FP002

7

120226

7

x1

D4170-1 Manufactured No

230 Each

166.0000

4

4

D4170-1

Bushing

**

BE15-0109

Location

Loc Qty

Loc Code

LG001

166

107896

89

119639

44

123940

33

4

D4171-1 Manufactured No

230 Each

7.0000

1

1

D4171-1

Bushing

**

15/01/13

Location

Loc Qty

Loc Code

ST096

7

125038

7

x1

MS21043-3 Purchased No

230 Each

426.0000

5

5

MS21043-3

Nut

**

15/01/13

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

294

m130673

294

x5

GA

52

m130673

52

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Parent Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

NAS1149C0363R

Purchased

No

230

Each

Start Qty: 1.00
962.0000 9 9

Required Qty: 1.00

NAS1149C0363R

Washer

lll 15/01/13

Location

Loc Qty

Loc Code

FP001

221

114742

221

GA

228

m130673

228

ST271

513

m130673

513

x9

NAS1515H3L

Purchased

No

230

Each

687.0000 4 4

***NAS1515H3L ***

Washer

lll 15/01/13

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

91

m127831

91

ST266

556

m127831

56

m130726

500

x4

NAS1611-010

Purchased

No

230

Each

172.0000 8 8

NAS1611-010

O-RING

lll 15/01/13

Location

Loc Qty

Loc Code

FP001

172

m130797

172

x8

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Parent Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

NAS1611-013 Purchased No 230 Each 942.0000 8 8 Start Qty: 1.00 Required Qty: 1.00

NAS1611-013

O-RING

**

1510113

Location Loc Qty Loc Code

FP001 942

m130758 942

V8

NAS1149D0863J Purchased No 250 Each 758.0000

NAS1149D0863J

Washer

DAS
46
Q-RQ

**

DAS

27

DAS

8-89

C6

9-89

151115

Location Loc Qty Loc Code

FP001 57

125484 57

ST260a 700

125268 600

125635 100

st268 1

125268 1

D2744 Manufactured No 110 Each 38.0000 1 1

D2744

Cap

**

BB 15-01-08

Location Loc Qty Loc Code

LG001 38

125894 38

D2600-3-BENT-RH Manufactured No 110 Each 4.0000 1 1

D2600-3-BENT-RH

Extrusion Bent RH

**

DGL 15-1-8

Location Loc Qty Loc Code

LG002 4

125888 4

1

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Parent Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

D2743 Manufactured No 160 Each 155.0000 8 8 Start Qty: 1.00 Required Qty: 1.00

D2743

Crossbolt Spacer

**

BE 15-01-09

Location Loc Qty Loc Code

LG001 155

125893 8

27636 147

D2739 Manufactured No 160 Each 10.0000 1 1

D2739

350 I Beam

**

DGC 15-1-81

Location Loc Qty Loc Code

LG003 10

125889 10

ALS4-1032-225 AELS8-1032-225 Purchased No 230 Each 1,546.000 4 4

ALS4-1032-225

Rivnut

**

all 15/01/13

Location Loc Qty Loc Code

FG 120

M127028 120

FP001 622

M131067 622

st549 804

M131067 804

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Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

AN8C35A	Purchased	No	230	Each	25.0000	1	1	Start Qty: 1.00	Required Qty: 1.00
AN8C35A								**	all 15/01/13
Bolt									

Location	Loc Qty	Loc Code
FG	5	
121275	5	
FP001	20	
m130114	1	
m130784	19	

AN6C44A	Purchased	No	230	Each	102.0000	4	4	Start Qty: 1.00	Required Qty: 1.00
AN6C44A								**	all 15/01/13
Bolt									

Location	Loc Qty	Loc Code
FG	2	
103964	2	
FP001	4	
m130863	4	
ST286A	17	
m130863	17	
ST332	11	
m130863	11	
ST333	68	
m131151	68	

MS21083C8	Purchased	No	230	Each	114.0000	1	1	Start Qty: 1.00	Required Qty: 1.00
MS21083C8								**	all 15/01/13
Nut									

Location	Loc Qty	Loc Code
ST300	114	
m131049	114	

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Picklist Print

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Work Order ID: 128136

128136

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

D3631-1 Manufactured No

230 Each

Start Qty: 1.00
170.0000 8 8

Required Qty: 1.00

D3631-1

Washer

**

15/01/13

Location

Loc Qty

Loc Code

FP001

170

125912

170

x 8

NAS1149C0332R

Purchased No

230 Each

4,371.000 4 4

NAS1149C0332R

WASHER

**

15/01/13

Location

Loc Qty

Loc Code

FP001

2581

m130325

2581

GA

126

125654

126

ST271

1664

m130325

664

m130466

1000

x 4

D2745

Manufactured No

230 Each

76.0000 8 8

D2745

Bushing

**

15/01/13

Location

Loc Qty

Loc Code

ST010

76

125895

76

y 2

NAS1149C0832R

Purchased No

230 Each

189.0000 1 1

NAS1149C0832R

Washer

**

15/01/13

Location

Loc Qty

Loc Code

FP001

45

m114915

45

ST271

144

m125807

144

x 1

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Thursday, January 08, 2015 8:41:15 AM

Work Order ID: 128136

128136

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

AN3C6A

Purchased

No

230

Each

608.0000

Start Qty: 1.00

4 4

Required Qty: 1.00

AN3C6A

Bolt

**

15/01/13

Location

Loc Qty

Loc Code

CA	39	
m128704	39	
FG	10	
122416	10	
FP001	118	
m128769	118	
ST338a	441	
m128769	441	

MS21043-6

Purchased

No

230

Each

206.0000

4 4

MS21043-6

NUT

**

15/01/13

Location

Loc Qty

Loc Code

FG	20	
103693	20	
FP001	186	
m130325	6	
m130726	180	

D3493-1

Manufactured

No

250

Each

109.0000

2 2

D3493-1

Washer

**

DAS 27 06
8-89 8-89

DAS
46
9-89

Location

Loc Qty

Loc Code

FG	10	
97201	10	
ST046	99	
125906	99	

15/11/15

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Page 11

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Work Order ID: 128136

128136

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No

250 Each

114.0000

2 2

MS21083C8

Nut

DAS
46
9-89

Location

Loc Qty

Loc Code

ST300

114

114

m131049

**

DAS

27

DAS

05

9-89

15/1/15

AN8C21A

Purchased No

250 Each

20.0000

2 2

AN8C21A

Bolt

DAS
46
9-89

Location

Loc Qty

Loc Code

FG

2

123966

2

ST332

18

18

m131100

**

DAS

27

DAS

05

9-89

15/1/15

D2741

Manufactured No

250 Each

11.0000

1 1

D2741

Replacement Blade

DAS
46
9-89

Location

Loc Qty

Loc Code

FG

10

100664

3

113640

2

115522

5

ST538

1

124047

1

**

DAS

27

DAS

05

9-89

15/1/15

B/25892

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Page 11

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0)
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0" ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER

NO. 128136 MJS
1501-08

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B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	B		
CHECKED	J		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D4168	REV. B
TITLE 350 SKIDTUBE ASSEMBLY	SHEET 1 OF 11
SCALE NTS	
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8 7 6 5 4 3 2 1

D

D

C

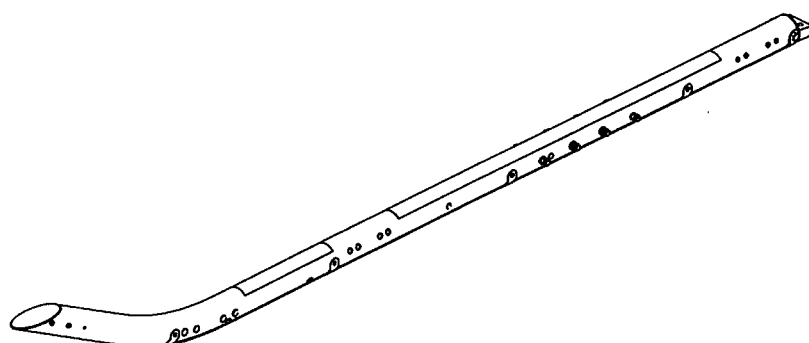
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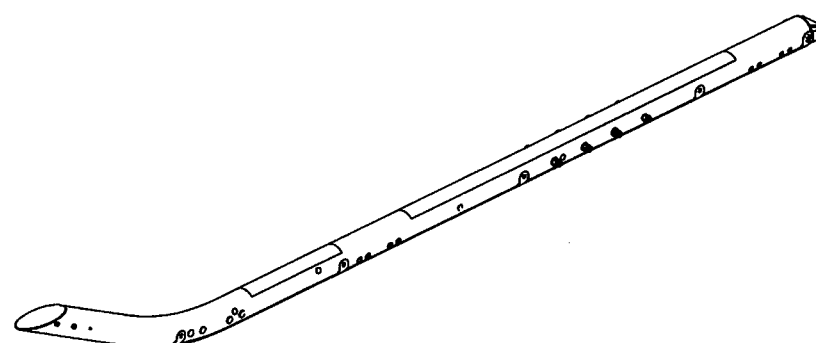
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A

A



D4168-041 350 SKIDTUBE ASSEMBLY, LH

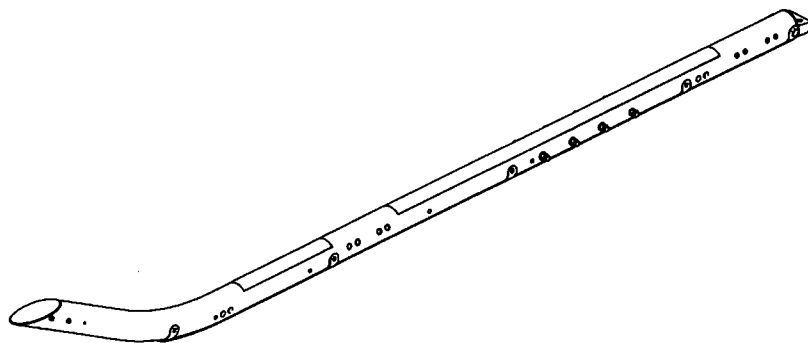


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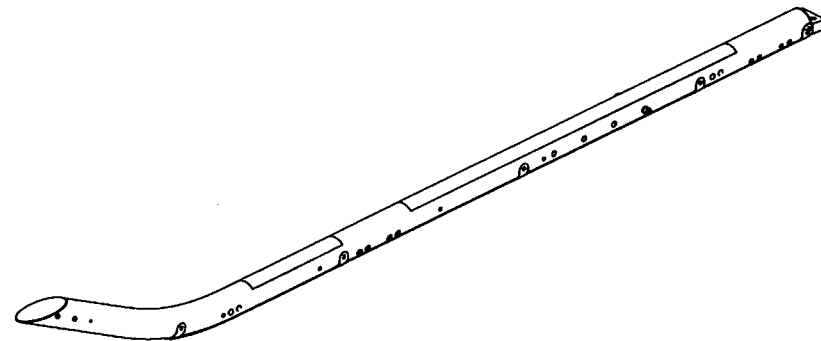
RELEASE
2013-08-13
mw

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DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4168	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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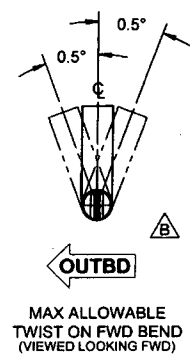
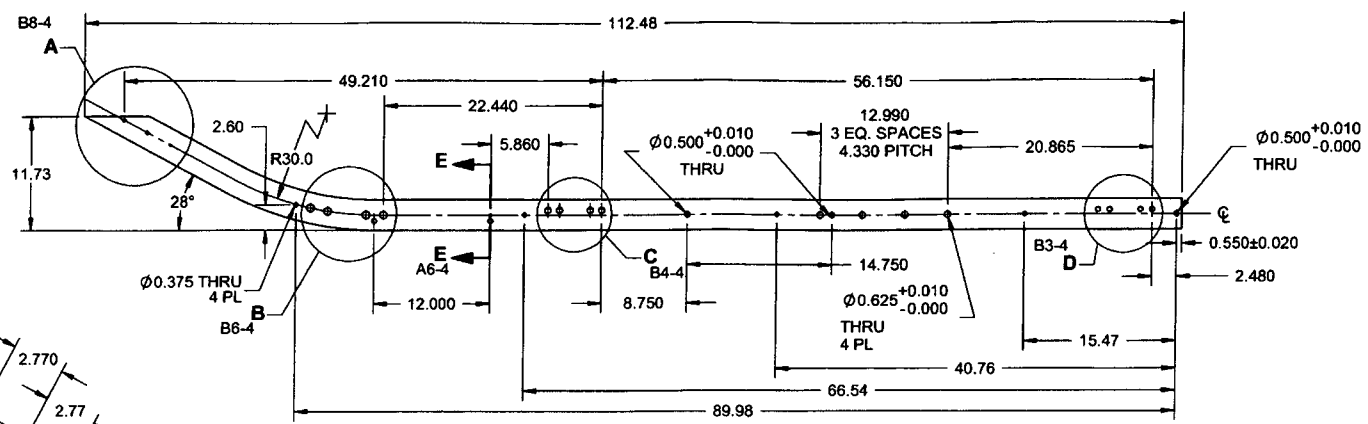
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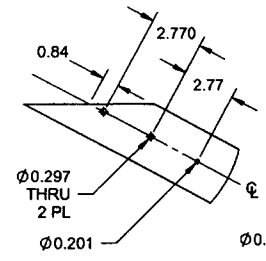
D4168-044 350 SKIDTUBE ASSEMBLY, RH

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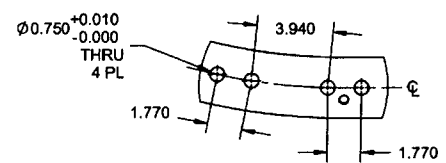
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MFG. APPR.		D4168	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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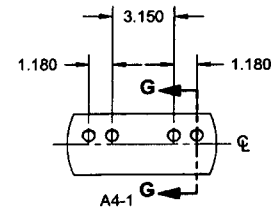
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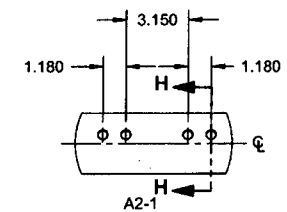
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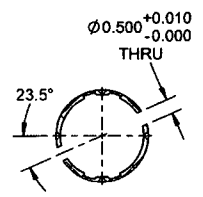
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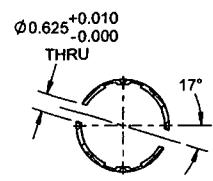
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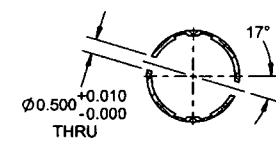
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SECTION E-E
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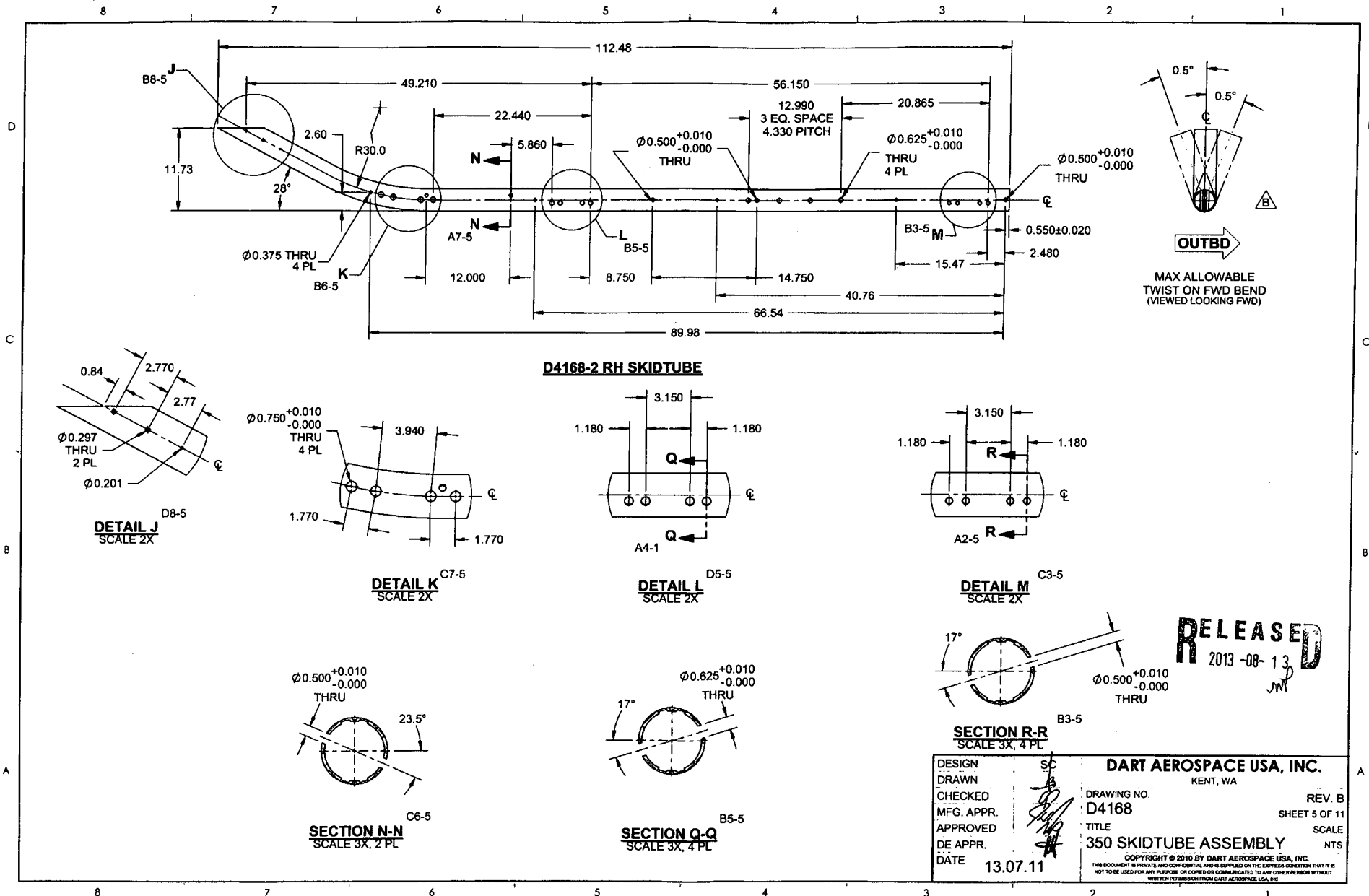
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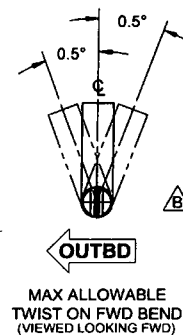
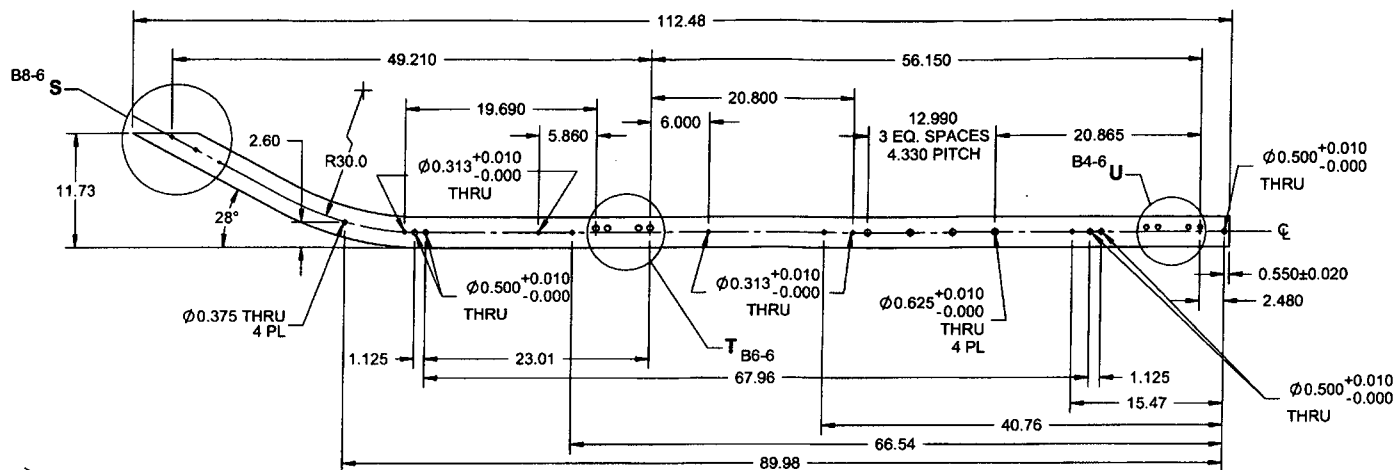


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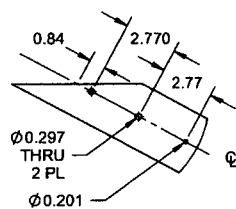
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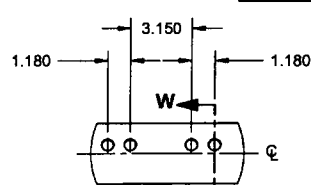




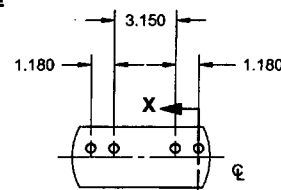
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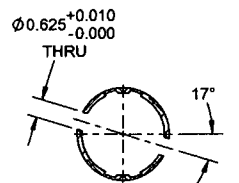
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D8-6
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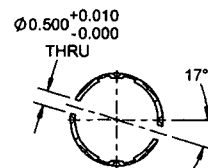
DETAIL T
C5-6
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DETAIL U
D3-6
SCALE 2X



SECTION W-W
B6-6
SCALE 3X, 4 PL



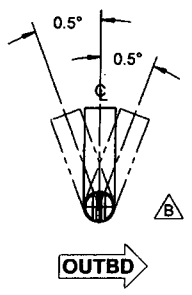
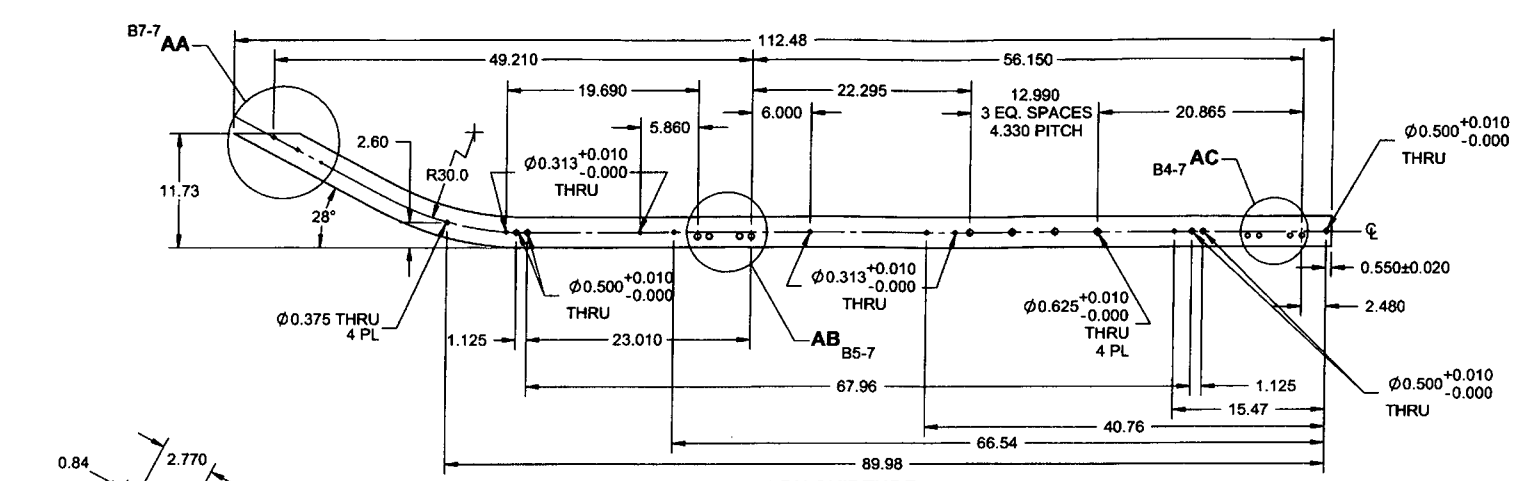
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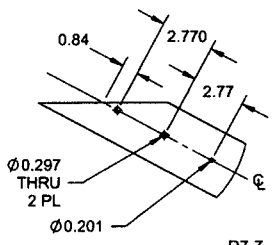
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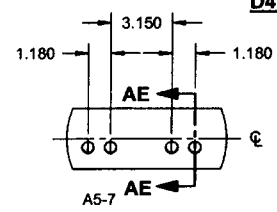
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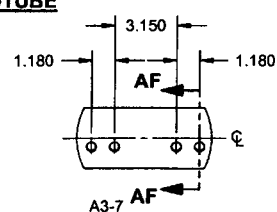
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TWIST ON FWD BEND
(VIEWED LOOKING FWD)



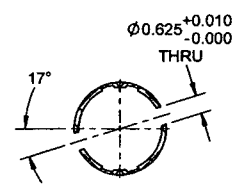
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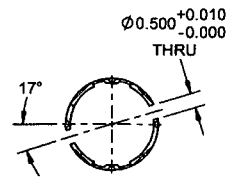
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C4-7
A5-7 AE



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A3-7 AF



SECTION AE-AE
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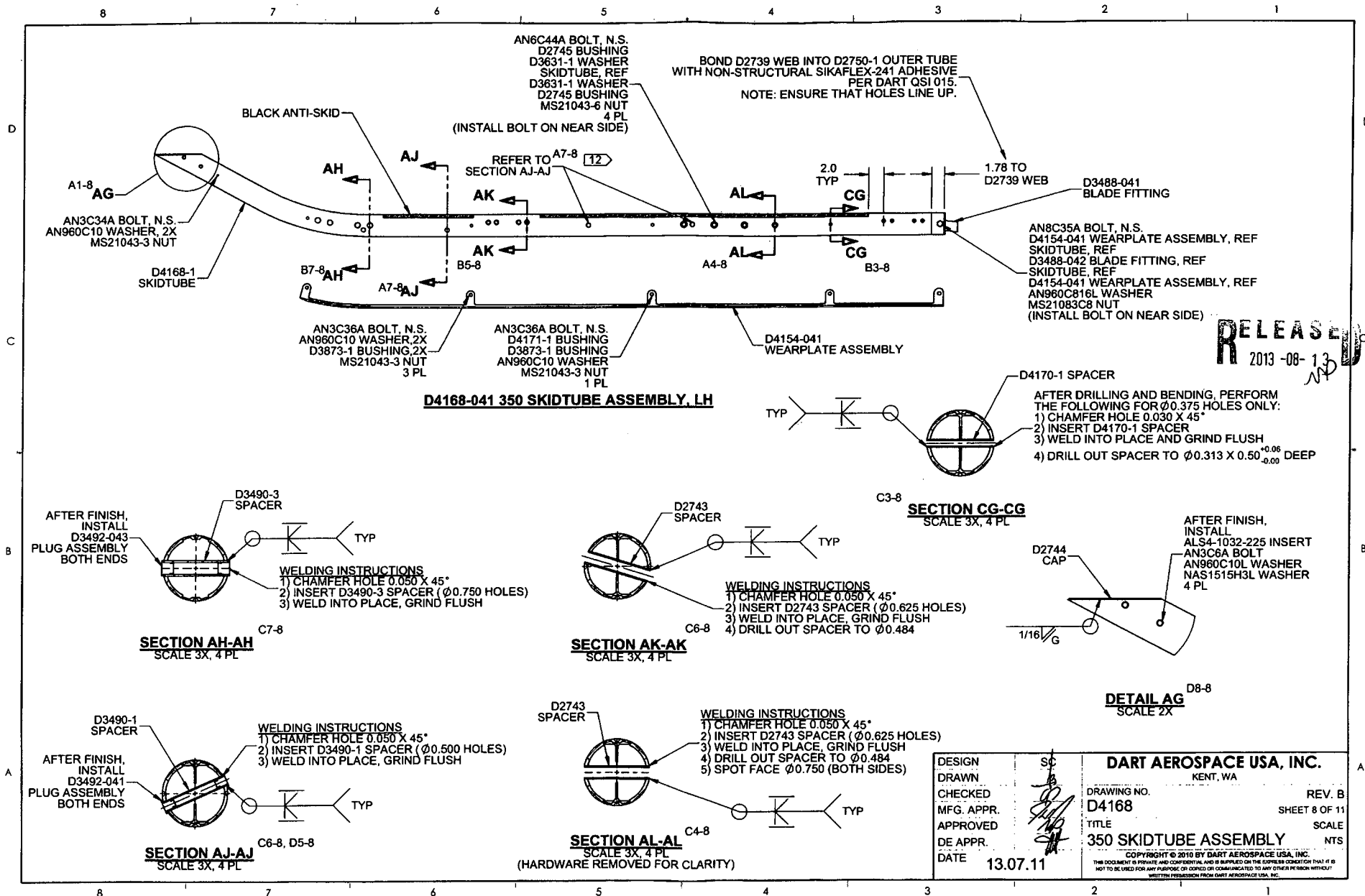


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8 7 6 5 4 3 2 1



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